

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>			
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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September-11-14 11:55:20 AM

Page 2

Quality Control

DAS
20 14-09-26
9-89

DAS 34 9-89

14/10/02
~~11/10~~

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Doc/Data									
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Handling/Prep									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
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		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

124123

September-11-14 11:55:20 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/04/14 Start Qty: 6.00 *6*

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 6.00 *6*

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

160

Small Fab

0.00

Small Fab

Memo

Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362 Batch M125831

Batch M, 25821

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: 51537 0.00

0.00

180

Packaging

Memo

0.00

Packaging

Work Order ID 124123

124123

Page 4

September-11-14 11:55:20 AM

Item ID: D2362-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Support Bracket

Start Date: 9/04/14 Start Qty: 6.00 *6*

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 6.00 *6*

Customer:

Reference:


Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

14/10/9 
MLJ 14-10-09

Picklist Print

September-11-14 11:55:20 AM

Page 1

Work Order ID: 124123

124123

Parent Item: D2362-3

D2362-3

Parent Item Name: Step Support Bracket

Start Date: 9/04/14

Required Date: 9/10/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: G00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2265		Manufactured	No			160	Each	48.0000	1	6			
D2265									**	6		DAS 20 9-89	14-09-25
Step Bracket													

Location	Loc Qty	Loc Code
ST488	48	
103258	28	
97950	20	

D2397-1		Manufactured	No			160	Each	8.0000	1	6			
D2397-1									**			DAS 36 9-89	14/10/06
Rubber Cushion													

Location	Loc Qty	Loc Code
ST006	8	
103806	4	
99483	4	

D2397-3		Manufactured	No			100	Each	8.0000	1	6			
D2397-3									**			DAS 36 9-89	14/10/06
Rubber Cushion													

Location	Loc Qty	Loc Code
ST006	8	
99484	8	

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order: 124123
Description: Step Support Bracket		Part Number: D2362-3
Inspection Dwg: D2362	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	.259	✓		SLOS	Vern
3.074	+/-0.010	3.071	✓		↓	
0.34	+/-0.030	.3345	✓			
0.77	+/-0.030	.7655	✓			
1.500	+/-0.010	1.500	✓			
1.000	+/-0.010	1.003	✓			
0.80	+/-0.030	.770	✓			
1.200	+/-0.010	1.205	✓			
1.28	+/-0.030	1.263	✓			
1.000	+/-0.010	1.005	✓			
0.75	+/-0.030	.761	✓			
1.88	+/-0.030	1.870	✓			

DAS

Measured by:	20 9-89
Date:	14-09-25

Audited by:	DA: 08 9-89
Date:	14/09/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	JH

DART**RELEASED**
98.12.14 KE

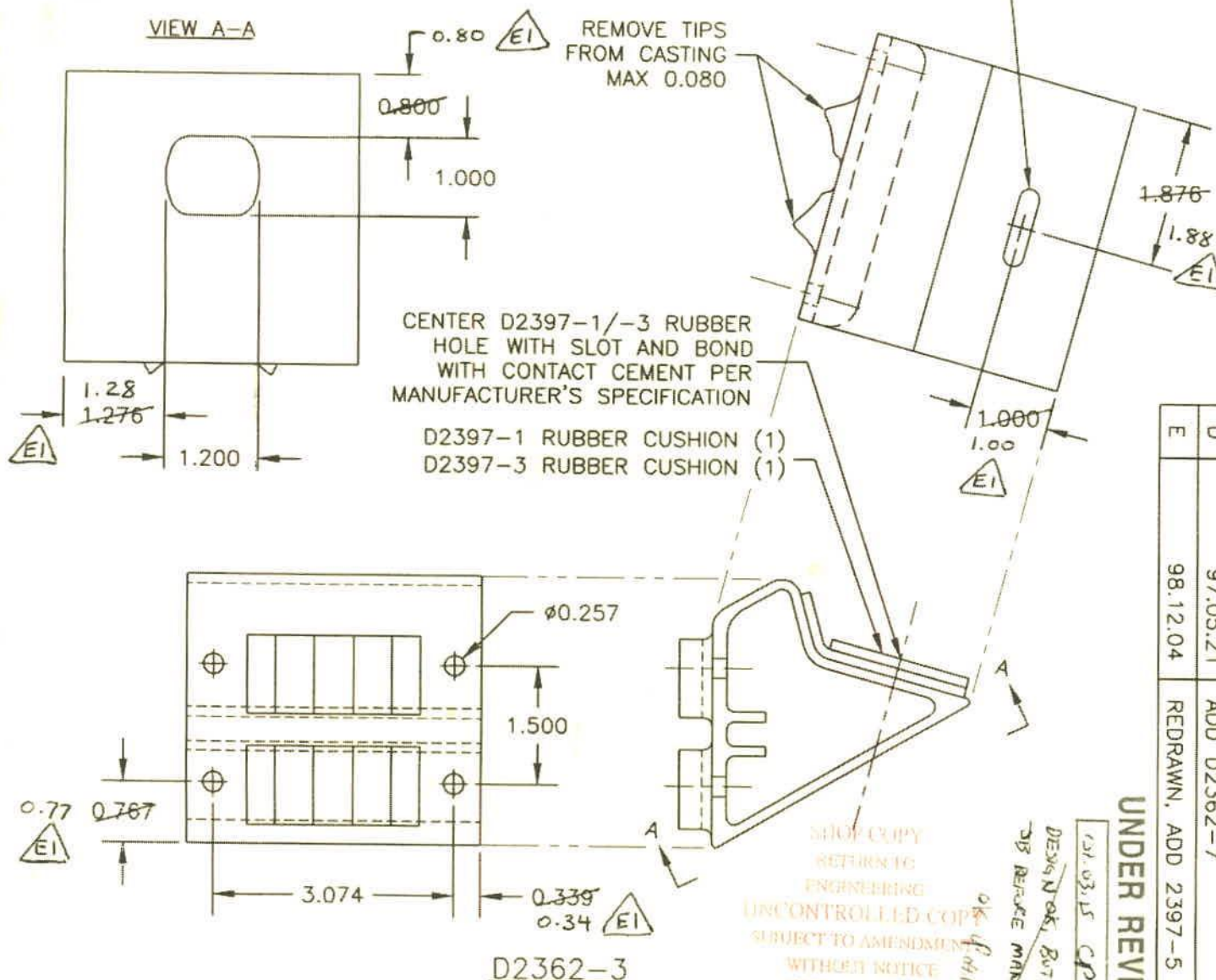
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>SP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>KE</i>	<i>SP</i>	D2362
DATE	TITLE	SHEET 1 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW131.03.15 *SP*DESIGN OK, BUT CHECK WITH
OR RE-MAKE MANUFACTURESHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124123
MLJ
14-09-12REMOVE TIPS
FROM CASTING
MAX 0.080

0.257 X 0.75 SLOT

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATIOND2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)D2362-3

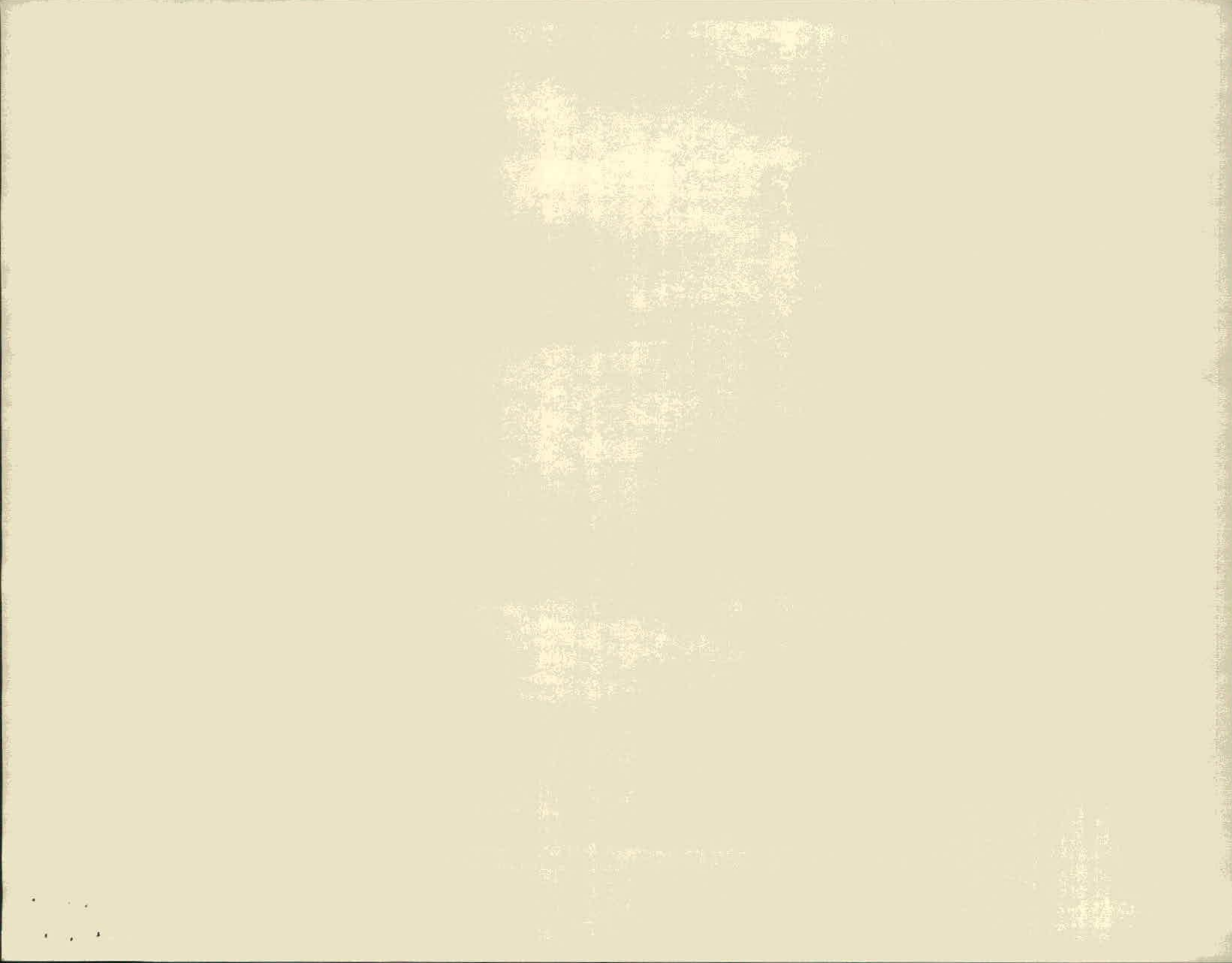
VIEW A-A

**NOTES:**

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DART



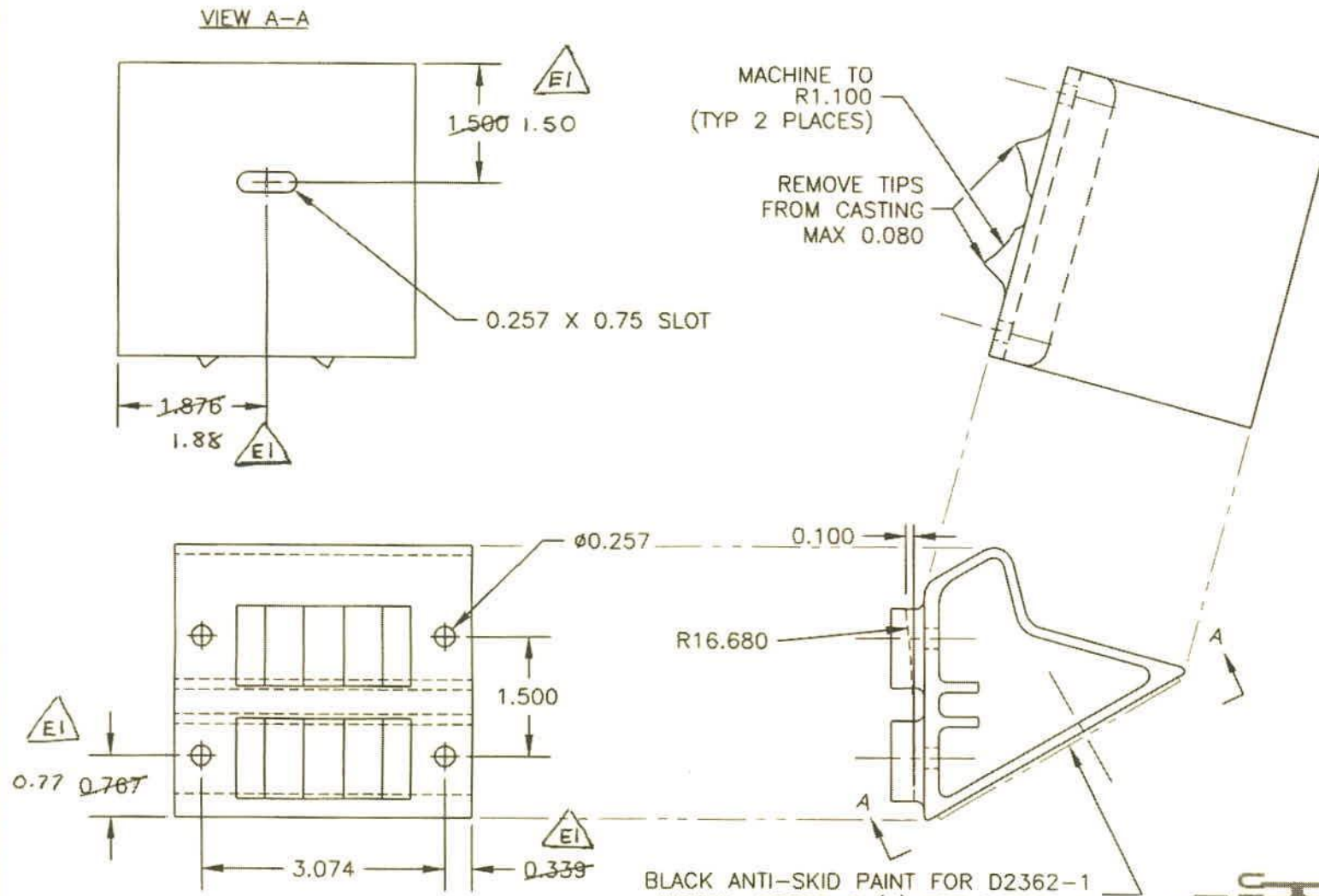
DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	CP	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	REV. E
				SHEET 2 OF 3
				SCALE 1:2

RELEASED
98.12.14
UNDER REVIEW

DESIGN OK, BUT CHECK BY
DB BEFORE MANUFACTURE
OK CP 12/14/98

BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5



- NOTES:**
 MAKE FROM D2265
 D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
 FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	MA	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	REV. E
				SHEET 3 OF 3
				SCALE 1:2

UNDER REVIEW

010315 CP

DESIGN OK, BUT CHECK WITH
JTS BEFORE MANUFACTURE

RELEASED
98.12.14 KE

D2362-041 (SHOWN)
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

